



BICHOthane 2C-PU SPRAY ENAMEL SILK GLOSS

2C spray enamel silk gloss based on PU/isocyanate resins

Description

Bichothane 2C-PU Spray Enamel Silk Gloss [3342] is a solvent based spray enamel silk gloss based on polyurethane resins combined with an aliphatic isocyanate hardener.

Available in almost any colors by the BC-S 8200 KMS. By using transparent fillers, the uncolored base paint can also be used as a clear coat. In that case, a hardener mixing ratio of 2:1 in parts by volume applies.

Properties

- Elastic
- Fine silk shiny appearance
- Good hardness and scratch resistance
- Long gloss and colour retention
- Good chemical resistance
- Fast drying
- Suitable for spraying
- Bichothane 2C products are lead and chromate free
- Available in all colours by the BC-S 8200 CMS, but can also be used as a clear coat without adding colorants.

Typical Applications

Bichothane 2C-PU Spray Enamel Silk Gloss [3342] can be used for various applications with high demands and an aesthetically pleasing finish is required (optimum flow behaviour): interior construction (kitchens, furniture, etc.) and industrial applications such as machines, equipment, rolling stock, constructions, etc.

Substrates

- Primed wood(like) (board) materials, MDF, etc. equipped with, for example:
 - [3349] Bichothane 2C PU HB Filling Bodyprimer White (10:1)
 - [9047] Bichothane 1C PU Filler Primer White
- Bipox 2C HB Zinc Phosphate Primer [6142] [6146]
- Bipox 2C HB Midcoat [6145]
- Various Bicholux QD primers
- Intact old paint layers

Technical Specifications

(ready mixed product at 20°C)

| | |
|-------------------------|--|
| Finish | : silk gloss |
| Gloss level (%) | : 35-65% (depending on colour) |
| Colour | : all colours by BICCS CMS BCS-8200 |
| Theoretical consumption | : approx. 10,5 m ² /ltr. at 40 µm DFT |
| Specific gravity | : 1,13 g/ml (depending on colour) |
| Solids content | : 54% by weight / 42% by volume |
| Flashpoint | : 21°C |
| Application conditions | : min. 5°C / 80% R.H. |
| VOC content | : 515 g/l |
| Shelf life in can | : 24 months in original unopened packaging, stored at 5 – 30°C. Frostproof storage. |

APPLICATION INSTRUCTIONS



Pre-treatment

The surface needs to be entirely clean, dry and degreased. Old, intact paint layers need to be abraded/sand papered. Pre-treatment (also) depends on the substrate, but in any way needs to be done in such a way that a solid and suitable substrate is obtained, suitable to be painted. See the additional info in this sheet.

Mixing ratio BC-S Colourants, 8200 series:

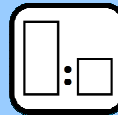
Add 20% BC-S Colourants (by volume)

Mixing ratio Hardener

Hardener : Bichothane 2C PU ST Hardener [3380]

Mixing ratio : 4:1 by volume (base:hardener)

Potlife : ca. 6 hours at 20°C



Pay attention! Basecoat and hardener have to be mixed carefully mechanically on the right scale. Because of quality loss, do not use products after expired potlife.

Viscosity and thinning

BICCS Thinner 0102 [9162]

Max. 10 – 15%.



Airspray

Nozzle : 1.2 – 1.5

Pressure : 3 to 4 bar

Viscosity : 18 – 22 sec., DIN cup 4

Airless

Nozzle : 0.009" – 0.011"

Pressure : 110 – 130 bar

Viscosity : 30 – 50 sec., DIN cup 4

Spraying instructions

Spray a thin base layer, followed by 1 – 2 cross-coats.

Recommended film thickness

Min. 100 µm WFT < > 40 µm DFT

Note: indicative layer thickness per layer. For system layer thicknesses in accordance with ISO 12944 (see 'BICCS Paint Systems', www.biccs.nl) or contact your account manager or the Technical Support department for project-based advice.

Tool cleaning:

Washing thinner or BICCS Thinner 0102 [9162]



Data at 20°C
and 65% RH

Drying times

Dust-free : approx. 30 minutes

Tack-free : approx. 60 minutes

For re-spraying : after 24 hours or after curing

(a little sanding is then required)

For sanding : after curing

Hard drying time : after 4 days

Additional information

Bichothane 2C-PU Spray Enamel Silk Gloss [3342] can be dried faster to a temperature of 60°C. In case of old, abraded paint layers there is a risk of burning particles.

For processing as a clear coat, a hardener mixing ratio of base : hardener 2 : 1 by volume applies.

Extra scratch and chemical resistance can be achieved by replacing Bichothane 2C PU Standard Hardener [3380] by Bichodur 2C Hardener [9280]. Base:hardener ratio remains equal.

Pay attention! Changing dosage of hardener can influence gloss rate.

Use of different thinners:

BICCS Thinner 0102 [9162] : standard thinner

BICCS Thinner 0110 [9110] : slow thinner; slows down the drying process/prevents respraying

BICCS Thinner 0105 [9165] : reactive thinner; speeds up the curing and drying process

(¹) Due to variable pigment content of/in the colour pastes, gloss degree of the end product may vary somewhat. Data in our datasheets are based on the average gloss degree of the RAL K7 colours, measured under an angle of 60° according to ISO 2813.

Pre-treatment

To prevent recurrent corrosion, the object/item needs to be coated immediately after blasting/grinding/degreasing. If there is any doubt about what's beneath the surface and/or about the pre-treatment, you always must do a trial to judge adhesion.

Application conditions

Data in this publication are based on a temperature of 20°C and a RH of 65%. In case of higher film thicknesses and/or lower temperatures, longer drying times apply. During application and drying, avoid temperatures lower than 10°C and an RH higher than 80%. The temperature of the object to be sprayed must be at least 3°C above dew point. See the dew point table on the download page of our website (www.biccs.nl). Good ventilation is required during application and drying.

Safety

Only for professional use. See the appropriate safety datasheet, downloadable from our website: www.biccs.nl.

For more information, please contact your BICCS account manager or the Technical Support department.

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